

## CLAIMS

What is claimed:

1. A belting fabric (100, 200) comprising a plurality of adjacently disposed couplets (110-119, 210-219) of weft yarns (105, 106, 206, 207) forming an upper layer of weft yarns and a lower layer of weft yarns, a plurality of binder warp yarns (120-122, 220-222) each extending over at least one of the couplets of weft yarns in the upper layer  
5 and under at least two of said adjacently disposed couplets of weft yarns in the lower layer, and middle warp yarns (107, 208) between the upper layer and the lower layers, wherein the middle warp yarns are sufficiently straight and inelastic to bear loads under tension without twisting or stretching.

2. The belting fabric in accordance with claim 1 wherein the middle warp yarns (107, 208) are formed of PET.

3. The belting fabric in accordance with claims 1 or 2 wherein the middle warp yarns (107, 208) have a denier of at least 550.

4. The belting fabric in accordance with claims 1-3 wherein the middle warp yarns (107, 208) are heat set under tension.

5. A method of making a belting fabric, the method comprising the steps of:  
arranging a plurality of couplets of weft yarns adjacent one another into an upper layer of weft yarns and a lower layer of weft yarns;  
weaving a plurality of middle warp yarns between the upper and lower  
5 layers;

weaving a first warp yarn over a first of said couplets of weft yarns and under a second and a third of said couplets of weft yarns, disposed adjacent said first of said couplets;

10 weaving a second warp yarn over a second of said couplets of weft yarns and under a third and fourth of said couplets of weft yarns, disposed adjacent said second of said couplets; and

weaving a third warp yarn over a third of said couplets of weft yarns and under fourth and fifth of said couplets of weft yarns, disposed adjacent said third of said couplets; and

15 heat setting the middle warp yarns.